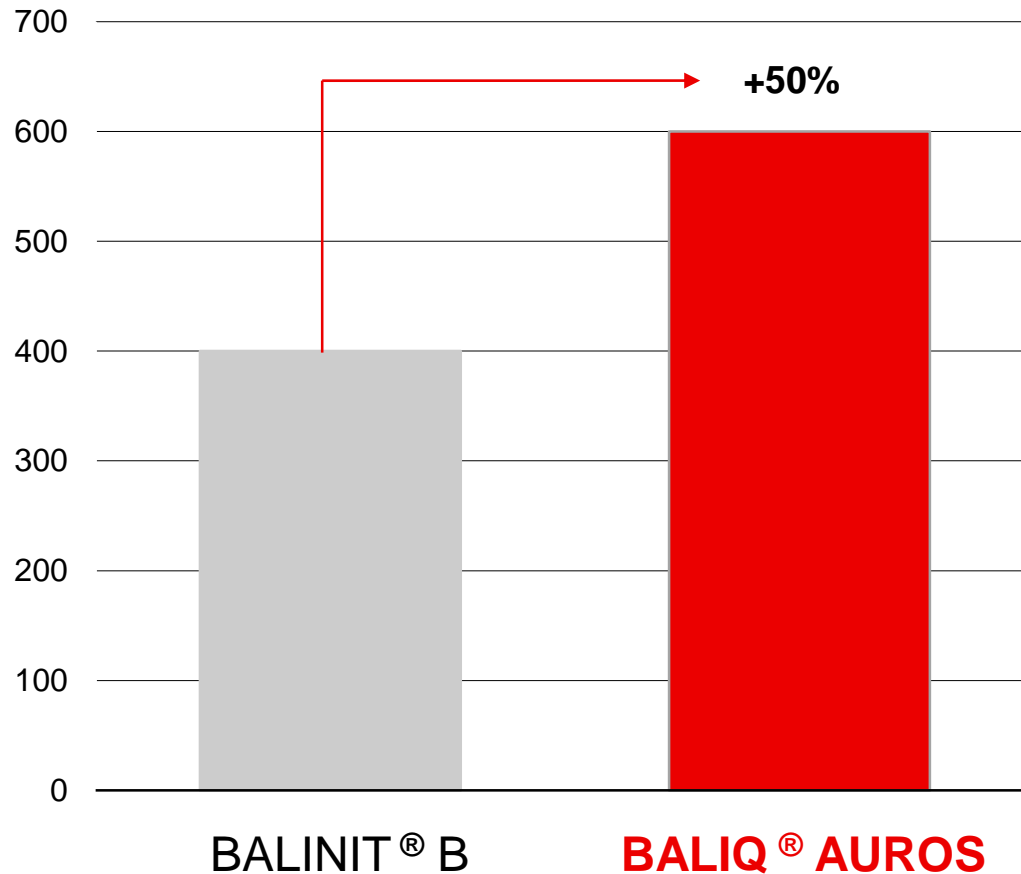


BALIQ AUROS

Tapping of low alloyed steel

Tool life [number of threads]



Tool

PM-HSS tap M15

Workpiece

Steel 1.7225, 42CrMo4
(AISI4140, SCM440)
1000 N/mm²

Cutting parameters

$v_c = 20$ m/min
Thread depth: 40 mm
Blind hole
Emulsion

Source

Tool manufacturer